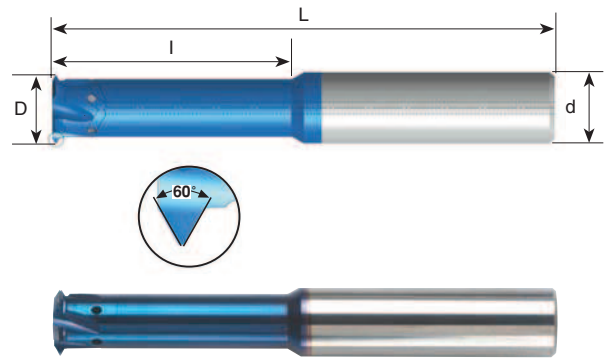


## Partial Profile 60°

With internal coolant through the flutes

Same Tool for Internal and External Thread



**For threading deep parts**

Pitch mm	Pitch TPI	Thread Dia. (min.)	Ordering Code	d	D	No. of Flutes	l	L
Int. 0.5 - 0.8 Ex. 0.4 - 0.8	56-28 64-32	$\varnothing \geq 6$	<b>MTI0605D20 A60</b>	6	5.0	4	20	58
		$\varnothing \geq 9$	<b>MTI0808D28 A60</b>	8	8.0	4	28	64
		$\varnothing \geq 13$	<b>MTI1212E38 A60</b>	12	12.0	5	38	84
Int. 1.0 - 1.75 Ex. 0.8 - 1.5	28-14 32-16	$\varnothing \geq 10$	<b>MTI0808D30 A60</b>	8	8.0	4	30	64
		$\varnothing \geq 12$	<b>MTI1010D35 A60</b>	10	10.0	4	35	73
		$\varnothing \geq 14$	<b>MTI1212E39 A60</b>	12	12.0	5	39	84
Int. 2.0 - 3.0 Ex. 1.75-2.5	13- 8 15-10	$\varnothing \geq 16$	<b>MTI1212E40 A60</b>	12	12.0	5	40	84
		$\varnothing \geq 18$	<b>MTI1614E45 A60</b>	16	14.0	5	45	101
		$\varnothing \geq 20$	<b>MTI1616E50 A60</b>	16	16.0	5	50	101

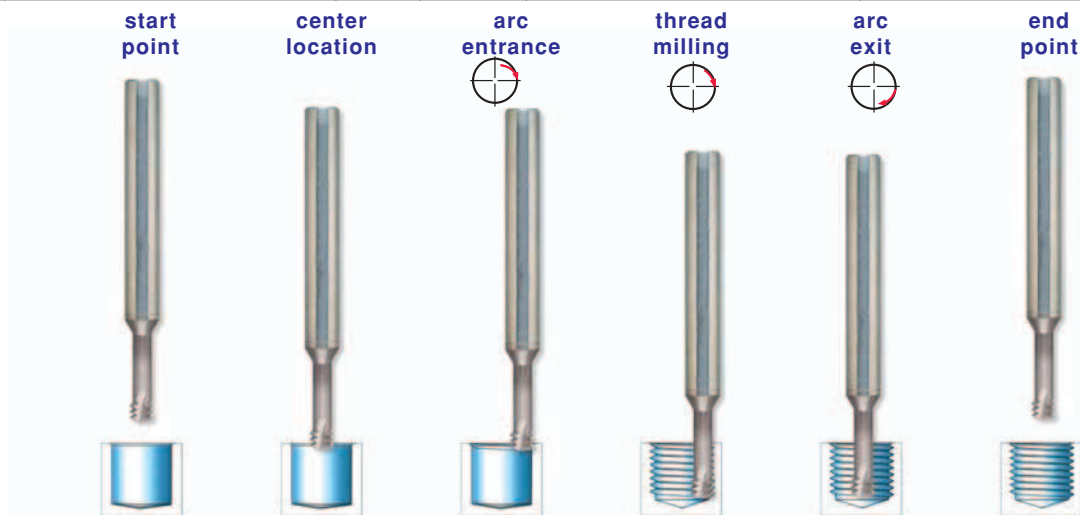
Order example: MTI 0808D28 A60 MT8

## Mini Mill Thread MTS and MTI types

**MT7** Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

**MT8** Sub-Micron Grade with Aluminium Titanium Nitride (AlTiN) multi-layer coating (ISO K10-K20). Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions. General purpose for all materials.

ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth													
			Cutting Diameter = D													
			ø1	ø1.5	ø2	ø3	ø4	ø5	ø6	ø7	ø8	ø9	ø10	ø12	ø14	ø16
<b>P</b>	Low & Medium Carbon Steels < 0.55%C	60-120	0.04	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
	High Carbon Steels ≥ 0.55%C	60-90	0.03	0.04	0.05	0.06	0.08	0.09	0.10	0.12	0.13	0.14	0.14	0.16	0.17	0.18
	Alloy Steels, Treated Steels	50-80	0.03	0.04	0.04	0.05	0.05	0.06	0.07	0.07	0.08	0.09	0.10	0.12	0.13	0.14
<b>M</b>	Stainless Steels - Free Cutting	70-100	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.12	0.13
	Stainless Steel-Austenitic	60-90	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.12	0.13
	Cast Steels	70-90	0.03	0.04	0.04	0.05	0.05	0.06	0.07	0.07	0.08	0.09	0.10	0.12	0.13	0.14
<b>K</b>	Cast Iron	40-80	0.04	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
<b>N</b>	Aluminium ≤10%Si, Copper	100-200	0.04	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
	Aluminium >10%Si	60-140	0.03	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.13	0.14
	Synthetics, Duroplastics, Thermoplastics	50-200	0.09	0.10	0.11	0.12	0.14	0.16	0.18	0.19	0.19	0.19	0.19	0.19	0.20	0.20
<b>S</b>	Nickel Alloys and Titanium Alloys	20-40	0.03	0.03	0.03	0.04	0.04	0.05	0.06	0.06	0.06	0.07	0.07	0.07	0.08	0.08



### Mini Mill-Thread vs. Taps

Features	Mini Mill-Thread	Taps
Thread surface quality	High	Medium
Thread geometry	Very accurate	Medium
Thread tolerances	4H, 5H, 6H with std cutter	6H with standard tap, 4H with specific tap
Machining time	Same as tap or shorter	Short
Tool breakage	Almost not possible	Could happen often
Machining load	Very low	High
Range of thread diameters	Wide range of diameters	Specific tap for each diameter
Right/Left hand threading	Same cutter	Specific tap for each
Geometric shape	Full profile	Partial profile